

303 Hex 0.500"

Work Order ID 77023

77023

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Thursday, November 24, 2011 3:23:16 PM

Item ID: D3622-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Ball Stud

Start Date: 11/24/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 12/5/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

11/24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3622*	C								

100

0.00

100

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per Dwg D3622 & Folio FA846

Dwg Rev: C

Folio Rev: N/A

Deburr as per Dwg

20 0 11/24/11

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

20 0 11/24/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77023***77023***

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Thursday, November 24, 2011 3:23:16 PM

Item ID: D3622-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Ball Stud
Start Date: 11/24/2011 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 12/5/2011 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>57070</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MF
11-12-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Thursday, November 24, 2011 3:23:20 PM

Page 1

Work Order ID: 77023

77023

Parent Item: D3622-3

D3622-3

Parent Item Name: Ball Stud

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500		Purchased	No			100	f	19.7545	0.108	2.273684			
M303H0 500									**	2.457'		11/12/04	
303 HEX BAR .500													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT037		19.7545					
						109778		19.7545		2.457'			

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 77024
Description: Ball Stud		Part Number: D3622-3
Inspection Dwg: D3622 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.19	+/-0.030	1.191	✓		SLO8 SLO2	
0.630	+/-0.010	0.628	✓		"	
0.563	+/-0.010	0.560	✓		"	
0.125	+/-0.010	0.120	✓		"	
0.155	+/-0.010	0.1565	✓		"	
Ø0.310	+/-0.010	Ø0.312	✓		"	
Ø0.215	+/-0.010	Ø0.217	✓		"	
Ø0.394	+/-0.010	Ø0.396	✓		"	
R0.007	+/-0.010	R.008	✓		"	
Major Ø	Min = 0.187 Max = 0.168	Ø0.186	✓		"	
M.O.W.	Min = 0.0.214 Max = 0.212	0.2125	✓		"	

Measured by: SL	Audited by: B.A	Preliminary Approval:
Date: 11/12/03	Date: 11/12/04	Date:

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	11.02.18	Dwg Rev updated	KJ	

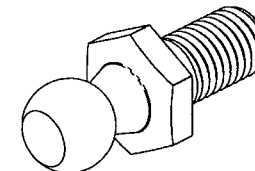
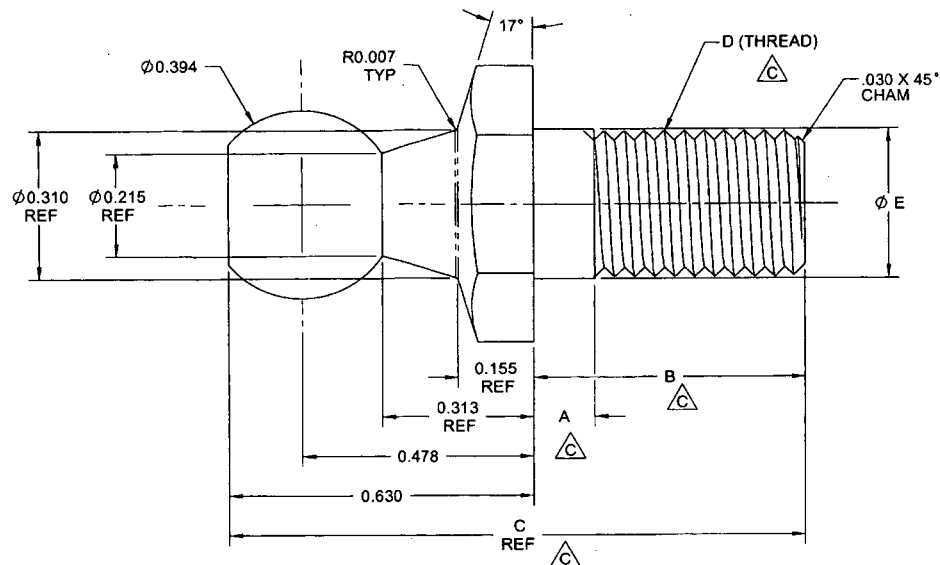
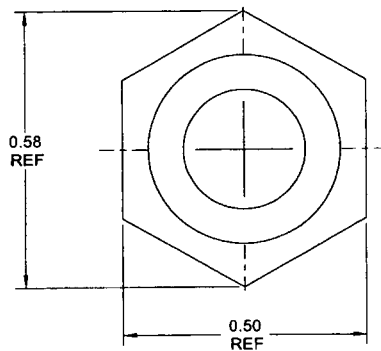
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

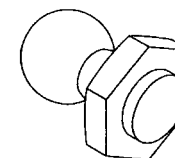
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**D3622-1 BALL STUD
SHOWN**



**D3622-11 BALL STUD
SHOWN**

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E	
						MIN	MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

D3622-X BALL STUD

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
- 7) WEIGHT: SEE D3622-X TABLE

SHO
REF
ENC
UNCON
SUBJECT
WITH
WO
NO. 77023

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.20		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3622 BALL STUD REV. C SHEET 1 OF 1 SCALE NTS <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

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